

Date: Monday, 3/17/2008 11:57:23 AM
User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	AFT CROSSTUBE		
Job Number	38044						
Estimate Number	10377						
P.O. Number	:			Part Number	D2890		
This Issue	3/17/2008	S.O. No.	:	Drawing Number	D2890 REV B		
Prsht Rev.	NC			Project Number	N/A		
First Issue	/ /			Drawing Revision	B		
Previous Run	38043			Material	:		
Written By	<i>John 08/03/17</i>			Due Date	4/4/2008		
Checked & Approved By				Qty:	1 Um: Each		
Comment	Est.	D	05.03.21	Removed Bending procedures	KJ/JLM		
Additional Product							
Job Number:							
Seq. #:	Machine Or Operation:			Description :			
1.0	D6008180			Crosstube extrusion 			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part # Description Batch 1 D6008-180 Crosstube extrusion <i>B23964 DD 8-3-27</i>							
2.0	BENDING			BENDING MACHINE 			
Comment: BENDING MACHINE <i>NP 8-3-27</i> 1-Bend D2890 as per Dwg D2890 and Folio FT002							
3.0	QC6			DIMENSIONAL CHECK 			
Comment: DIMENSIONAL CHECK <i>NP 08/03/27</i>							
4.0	LANDING GEAR 1			LANDING GEAR RESOURCE 1 			
Comment: LANDING GEAR RESOURCE 1 <i>NIA</i>							
1-Deburr and Polish							
5.0	HAND FINISHING1			HAND FINISHING RESOURCE #1 			
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 <i>NIA</i>							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: AFT CROSSTUBE

Job Number: 38044

Part Number: D2890

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/ CHEMICAL CONVERSION



N/A



Comment: INSPECT POWDER COAT/ CHEMICAL CONVERSION

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WO 37939

080403

8.0 QC21

FINAL INSPECTION/W/O RELEASE



080403

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



080403

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD

Work Order:

38044

Description: Crosstube Aft

Part Number:

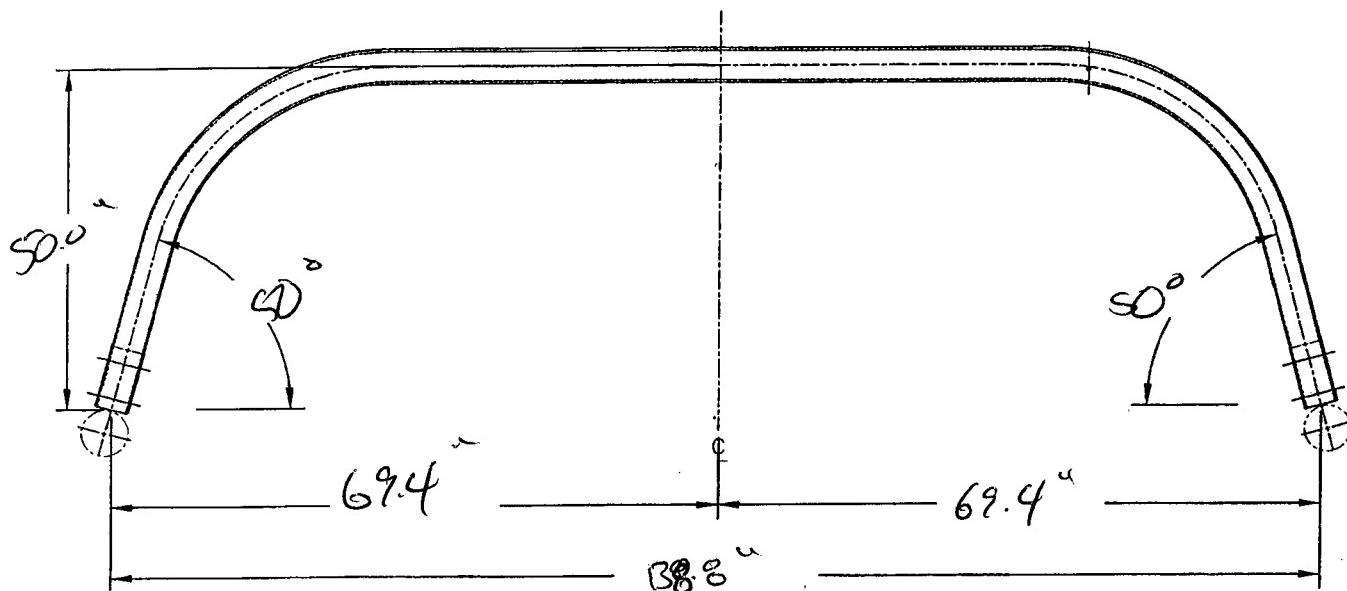
D2890

Inspection Dwg: D2890

Rev: B

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Required Dimension	Min	Max
Height	49.875	50.125
1/2 Span	69.275	69.525
Angle	49	52
Total Span	138.55	139.05



Comments	

QC15 Inspection	
Date	02/03/07

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	

DART**RELEASED**
02.10.28

DESIGN	DRAWN BY	DART AEROSPACE LTD		
CHECKED	APPROVED	DRAWING NO.	REV. B	SHEET 1 OF 1
		D2890		
DATE 02.10.18		TITLE AFT CROSSTUBE		SCALE 1:20
A	99.05.21	NEW ISSUE		
B	02.10.18	ADD TANGENT LENGTHS; CHANGE NOTES		

